Sep Monday 24/03 Rev E DAS 16 9-89 14/03/26

Work Order ID 115218

March-18-14 11:40:45 AM

115218 PRELIMINARY ISSUE

Item ID: D4541-3 D4541-3

Revision ID:

Item Name: Bracket B115218

Start Date: 3/18/14 **Start Qty:** 8.00 *8*

Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*

Reference: -

Accept *N9000040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MC5 **Date:** 14-03-19 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4541	**Revision Nbr** PE2 Rev E DAS 27 9-89								
100	DAS 10 9-89	0.00							
100									
Waterjet		0.00				8	mm/ez	14/03/24	
FLOW CNC Waterjet	**Memo** 1- Cut as per dwg D4541-3F Prog rev: D4541 Dwg rev: PE2 2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC		0.00				8	mm/ez	14/03/24	
Quality Control	**Memo**								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115218

March-18-14 11:40:45 AM

115218

Item ID: D4541-3
Revision ID:
Item Name: Bracket
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N9000040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89 14/3/25				8			
120									
QC	**Memo**	0.00							
Quality Control						Inspect as per Dwg PE2			
130		0.00							14/03/25
130					DAS 30 9-89	8			
Small Fab	**Memo**	0.00							
Small Fab	Bend each tab as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						8			
QC	**Memo**	0.00 DAS 27 9-89 14/3/25							
Quality Control						Inspect as per Dwg PE2			

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
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General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 115218

March-18-14 11:40:45 AM

115218

Item ID: D4541-3
Revision ID:
Item Name: Bracket
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00				8	YG	14325	
144 HandFinish Hand Finishing	**Memo**	0.00							
146	QC7-Inspect Chemical Conversion Coat	0.00 DAS 27 9-89				8			
146 QC Quality Control	**Memo**	0.00 14/3/26				Inspect 3 pcs per PEP			
150	Identify as per dwg & Stock Location: 54523	0.00				8			
150 Packaging Packaging	**Memo**	0.00				DAS 28 9-89		MAR 2 6 2014	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115218

March-18-14 11:40:45 AM

115218

Item ID: D4541-3
Revision ID:
Item Name: Bracket
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160						MLJ 14-03-26			
QC	**Memo**	0.00							
Quality Control									

MF 14-3-26

POSITIVE RECALL
EFFECTIVE 4/03/14 DAS 16 9-89 AUTH LL
RELEASED DATE 14/03/26

Release Dwg or Rev E

DAS 27 9-89 14/3/26

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

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☐ Drawing
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☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

March-18-14 11:40:48 AM

1

Work Order ID: 115218 *115218*

Parent Item: D4541-3 *D4541-3*

Parent Item Name: Bracket

Start Date: 3/18/14 **Required Date:** 4/01/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	410.6032	0.633	6			
M6061T6S.032									**		4.3 mm	14/03/24	

6061-T6 Sheet 0.032"

Location	Loc Qty	Loc Code	
MAT021	410.60317		
123483	8.57		
m125822	17		
m127272	128.75317		
~~m128054~~	256.28		4.3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

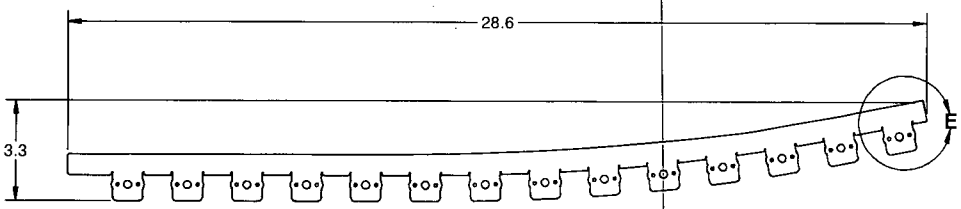
FAULT CATEGORY

Landing Gear

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☐ Cracks
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☐ Heat Treat
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☐ Marks/Chatter
☐ Turning Sequence
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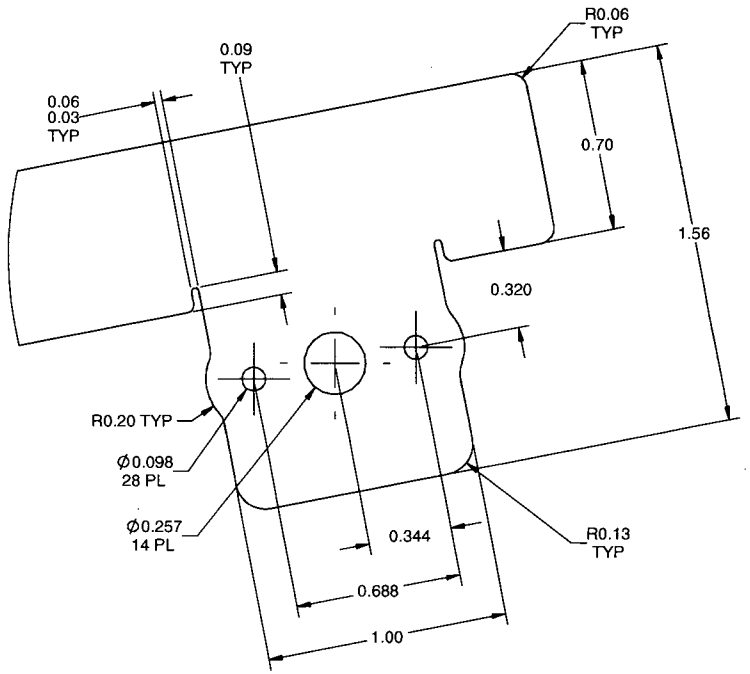
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
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☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



D4541-3F FLAT PATTERN

GRAIN DIRECTION



DETAIL E
TYP TAB DETAIL
SCALE 4X

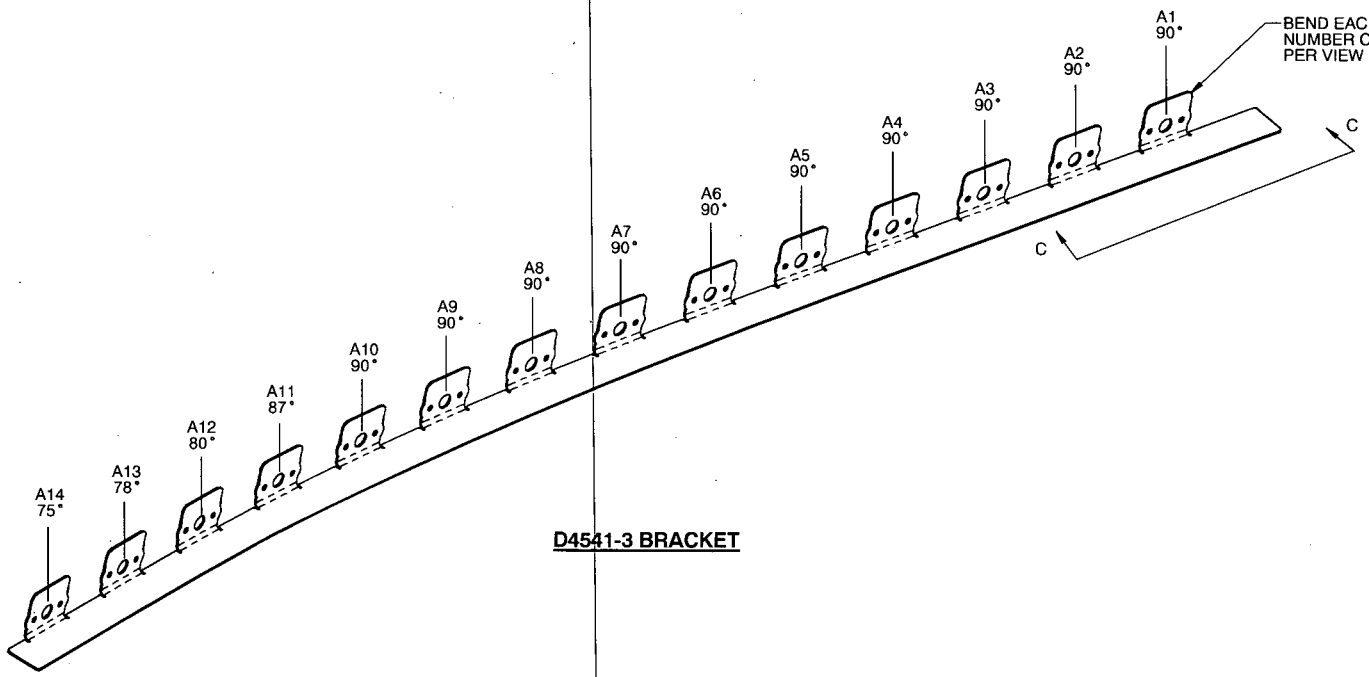
WO 45218

PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs
8) PROFILE PER DRAWING FILE "D4541-3F-REVE.DXF"

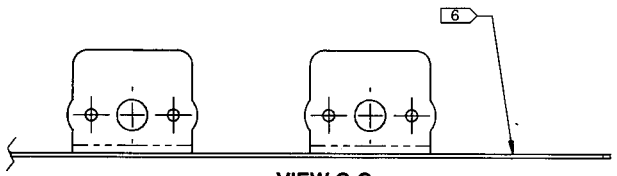
DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE2
MFG. APPR.		D4541	SHEET 7 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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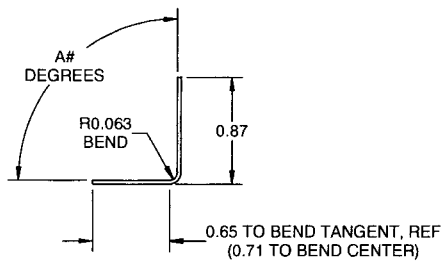


BEND EACH TAB THE INDICATED NUMBER OF DEGREES PER VIEW C-C

D4541-3 BRACKET



VIEW C-C
TYP TAB DETAIL
NOT TO SCALE



PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: MAKE FROM D4541-3F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.09 lbs

DESIGN	CP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 5 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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DART AEROSPACE LTD	Work Order:	115218
Description: Bracket	Part Number:	D4541-3
Inspection Dwg: D4541 Rev: E2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.3	+/- 0.10	3.3	✓	T	Jkm-07	
28.6	+/- 0.100	28.6	✓	V	Jkm-05	
1.56	+/- 0.03	1.56	✓			
1.00	+/- 0.03	0.999	✓			
0.688	+/- 0.010	0.688	✓			
0.344	+/- 0.010	0.344	✓			
ϕ 0.098	+0.004 -0.001	0.97	✓			
ϕ 0.257	+/ 0.005 -0.001	0.256	✓			
0.70	+/- 0.03	0.71	✓			
0.320	+/- 0.010	0.320	✓			

Measured by:	mm/ EZ
Date:	14/03/24

Audited by:	~~DAS~~ 27 9-89
Date:	14/3/25

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD

DART AEROSP

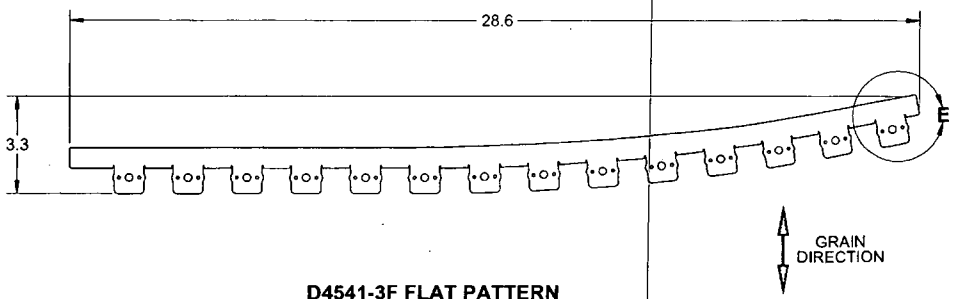
Description: Bracket Work Order: 115218

Inspection Drawing: D4541-3 Rev: PE 2 Part Number: D 4541-3

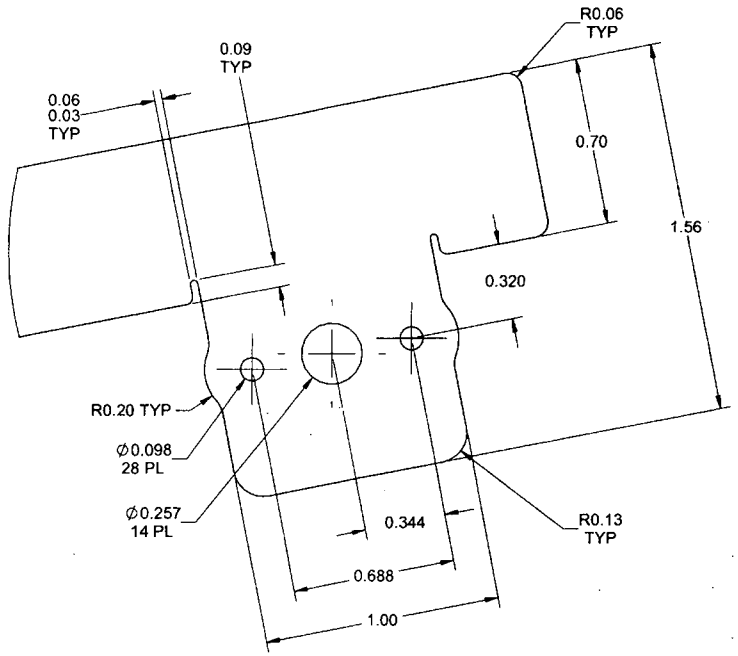
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.87	+/- .010	.873	/		V	SA-11
.65	+/- .030	.659	/		V	SA-11
90°	+/- 1/2°	90°	/		angle protector	SA-7
87°	+/- 1/2°	87°	/		"	SA-7
80°	+/- 1/2°	80°	/		"	SA-7
78°	+/- 1/2°	78°	/		"	SA-7
75°	+/- 1/2°	75°	/		"	SA-7

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessa*
DAS 30 9-89	DAS 36 9-89	DAS 27 9-89	
Date 14/03/25	Date 14/03/25	Date 14/3/25	Date



D4541-3F FLAT PATTERN



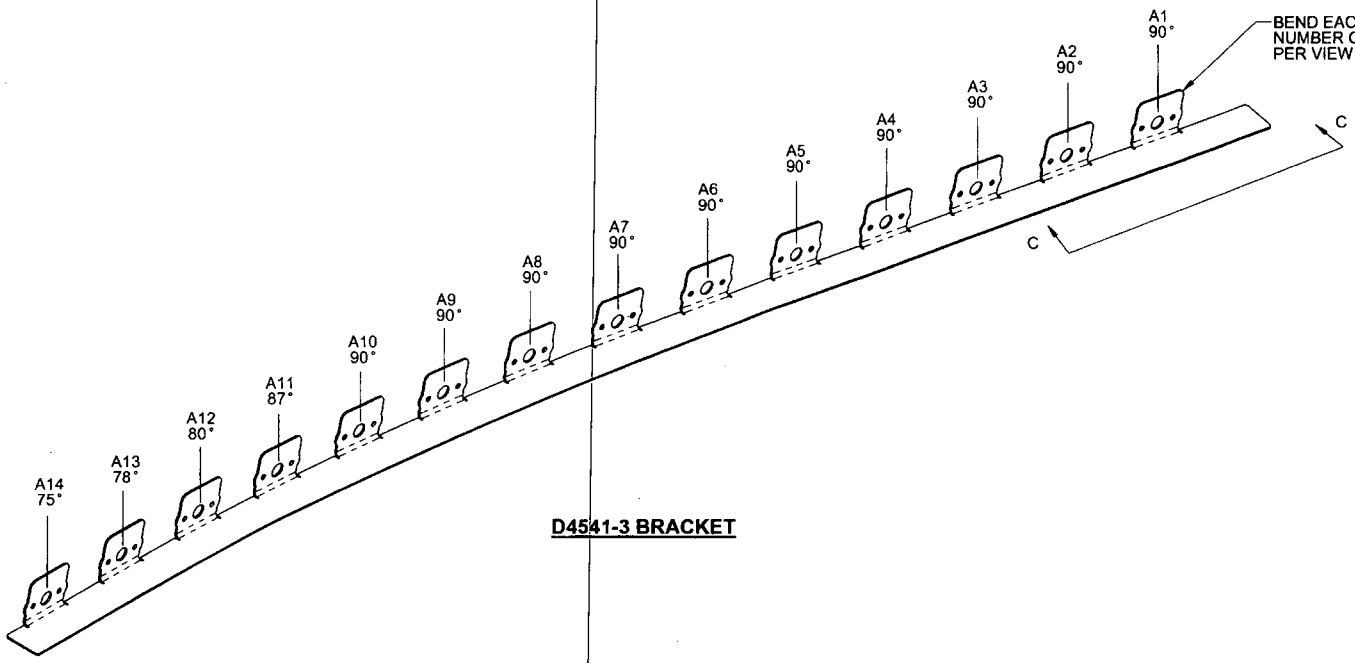
DETAIL E
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs
8) PROFILE PER DRAWING FILE "D4541-3F-REVE.DXF"

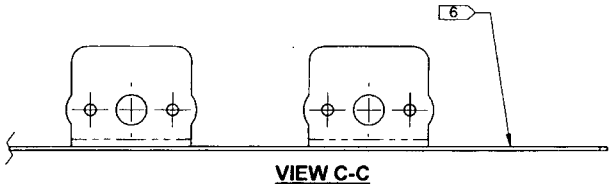
RELEASED
2014-05-26

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4541	REV. E
MFG. APPR.			SHEET 7 OF 13
APPROVED		TITLE BRACKET	SCALE NTS
DE APPR.			
DATE	14.03.07		

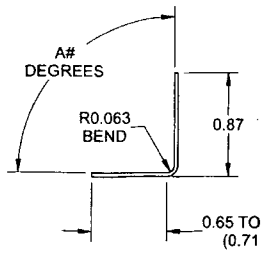
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D4541-3 BRACKET



VIEW C-C
TYP TAB DETAIL
NOT TO SCALE



RELEASED
2014-03-26

NOTES:
1) MATERIAL: MAKE FROM D4541-3F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.09 lbs

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 REV. E
MFG. APPR.		SHEET 5 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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